

# Work Order ID 74314

Wednesday, September 28, 2011 11:40:49 A



Page 1

Item ID: D3283-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 9/28/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan: H.L.J

Date: 9/29/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3283

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3283 11 Dwg Rev: E 11 Prog Rev: E 12-  
Deburr if necessary

6061-063

131-10-31

36

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

131-14-31

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/11/01 36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item Name: Doubler

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Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

N/A

0.00

Small Fab

Deburr

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

\*\*\*\*\*ensure rivet fits in #30 (0.128") holes as per dwg \*\*\*\*\*

W 11 / 11 / 01 (36)

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

36 11-11-1

Dart Aerospace Ltd

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**Work Order ID 74314**

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Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 9/28/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

36x Ø m-11/11/01

170

Identify as per dwg &amp; Stock Location: 45

0.00



Packaging

Memo

0.00

Packaging

11/11/15 (36)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/02

mf  
11-11-01

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Wednesday, September 28, 2011 11:40:46 AM

Page 1

Work Order ID: 74314



Parent Item: D3283-1



Parent Item Name: Doubler

Start Date: 9/28/2011

Required Date: 10/5/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP [1A]04.09.28[ ]New issue[ ]KJ/JLM[ ]  
IPP Rev:B Now on Waterjet 07-05-28 JLM  
IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	129.4456	0.2361	7.455789	8.5		
6061-T6 .063 Sheet													



HB 11-10-31

Location

Loc Qty

Loc Code

MAT021

129.4455684

116308

26.9755684

117285

91.47

118580

11

118580

36

**Dart Aerospace Ltd**

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**Dart Aerospace Ltd**

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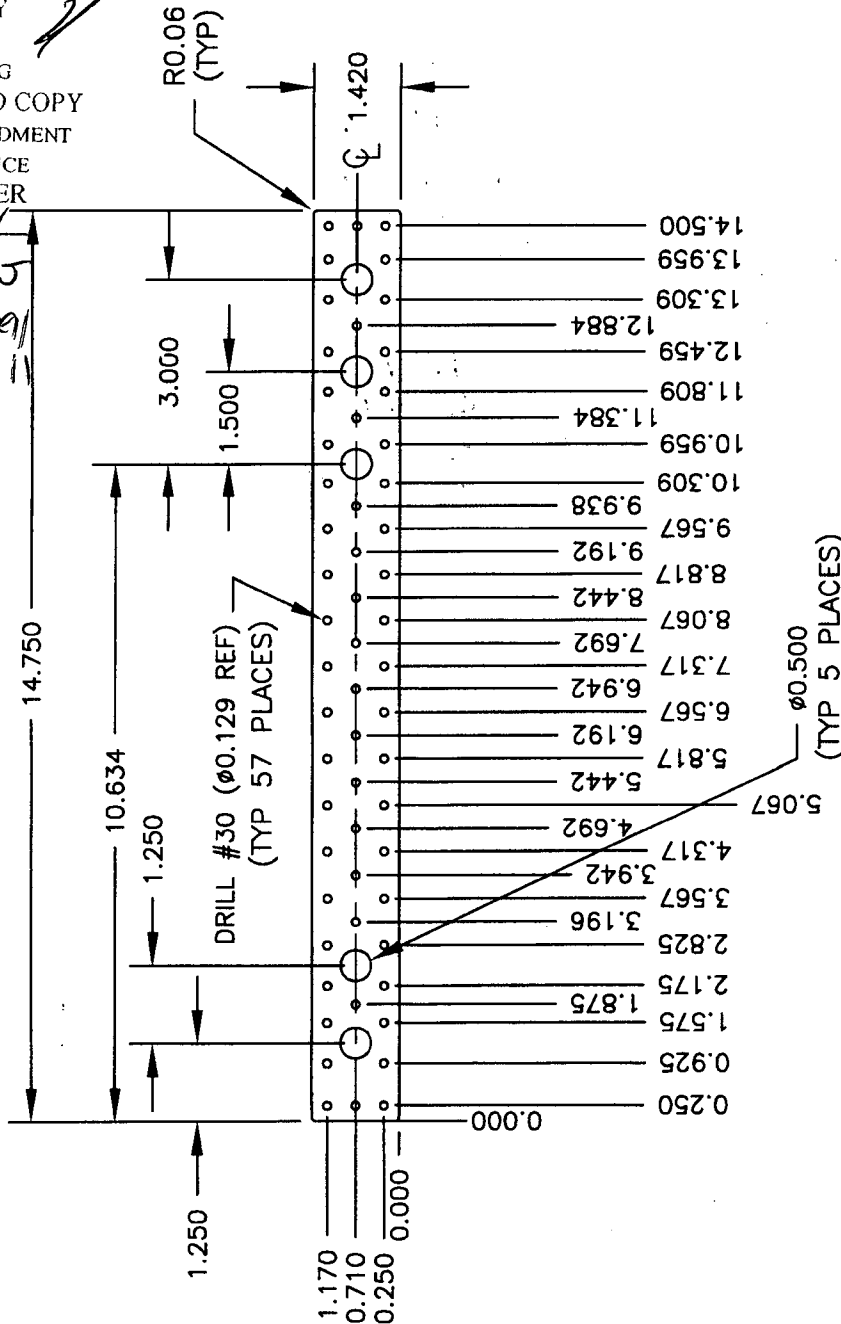


DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>B</i>	APPROVED <i>DC</i>	DRAWING NO. D3283	REV. E SHEET 1 OF 2
DATE 07.06.01		TITLE DOUBLER	SCALE 1:3
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR -1	
D	05.08.09	REDESIGN	
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)	

**RELEASED**  
07.08.2004  
PER ECN 959

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *34314*

*MLJ*  
*9/2/16*



**D3283-1 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

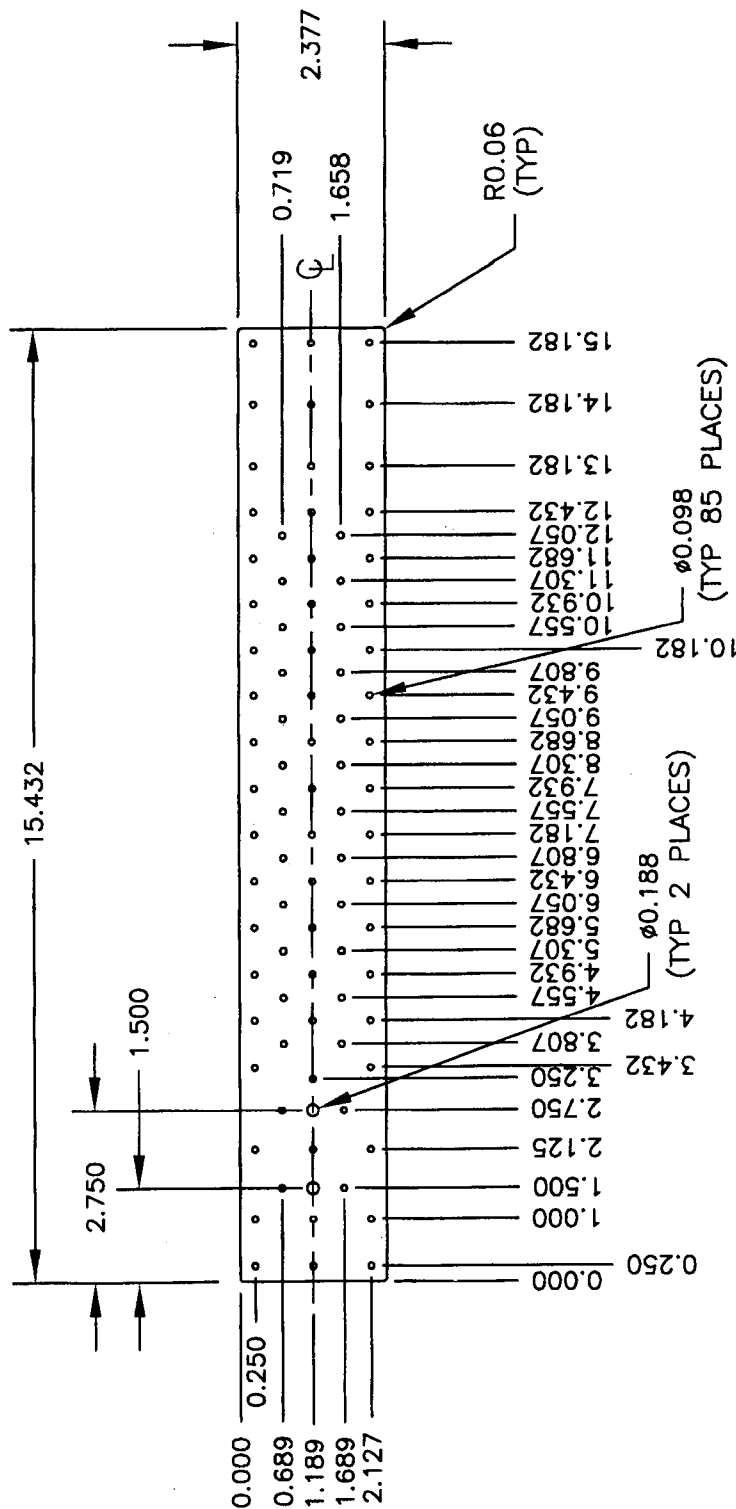
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>AB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3283	REV. E SHEET 2 OF 2
DATE 07.06.01		TITLE DOUBLER SCALE 1:3	

**RELEASED**  
07.08.2004  
PER ECN 959



**D3283-3 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

high

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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